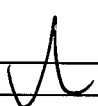


Black

Dart Aerospace Ltd.

Date: Tuesday, 04/11/2008 8:53:10 AM
 User: Linda Lacelle

Process Sheet

| | | | |
|------------------------------------|---|---------------------------|-----------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | STUB COVER |
| Job Number : | 43182 | | |
| Estimate Number : | 12415 | | |
| P.O. Number : | | Part Number : | D34941 |
| This Issue : | 04/11/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3494 PROTOTYPE |
| First Issue : | / / | Project Number : | N/A |
| Previous Run : | 41956 | Drawing Revision : | 8C |
| Written By : |  | Material : | |
| Checked & Approved By : | | Due Date : | 11/11/2008 |
| Comment : | Est Rev:A New Issue 06-05-18 JLM est rev B ecn 888 06.12.13 EC | | |

Additional Product

PROTOTYPE
 FOR ENGINEERING USE ONLY

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 Sheet .063 |
|-----|-----------|--------------------|



Comment: Qty.: 0.6972 sf(s)/Unit Total: 0.6972 sf(s)

304/316 .063 Sheet 108724 B 8-12-15
 (M304S16GA)
 Batch: 109057 B 8-11-5

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3494

Dwg Rev: C

Prog Rev: C

ATTN: REV.C

B 8-11-5

B 8-12-15

4

2-Deburr if necessary

B 8-11-5

B 8-12-15

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

08-12-17 4 08-11-11 2

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3494


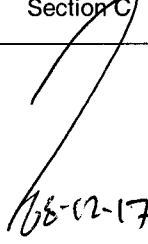
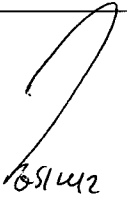


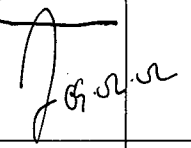

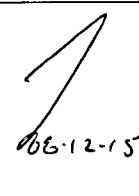



ATTN: REV.C

83 08/12/10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3494-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: 43182 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|---|---|---|---|--|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/12/12 | S | - 1 part was scrap - Incorrect die radius resulting in not being able to achieve dwg dimensions. |  | Scrapo replace Qty 4 were cut as replacements. | JB 8-12-17 |  |  |  |
| | | |  | Order a 1/16" radius die for bending. See P/O as reference. |  | |  |  |
| 08/12/17 | SO | 3 parts were scrap due to Set-up; parts being out of tolerance to the dwg. |  | - Review dwg & update the 2 dimensions on the height, to achieve the correct length & width. | SB 08/12/17 | |  |  |

NOTE: Date & initial all entries

Date: Tuesday, 04/11/2008 8:53:10 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STUB COVER

Job Number: 43182

Part Number: D34941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-02-01

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3494

A/R SS ROD

Batch: *M106762*

09-03-02

x1

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-03

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-03

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:00

OVEN TEMPERATURE:

320°

FINISH TIME:

8:30

FD 09/03/04

1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-04

0

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *187*

Red Tagged and put in Eng Lab. 9/13/04

1/1

50

13.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

ASS 09/04/04 ENGINEERING

09/03/05

MF 09-03-04

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D350-616

Job #: 00569

Date: 08.10.31

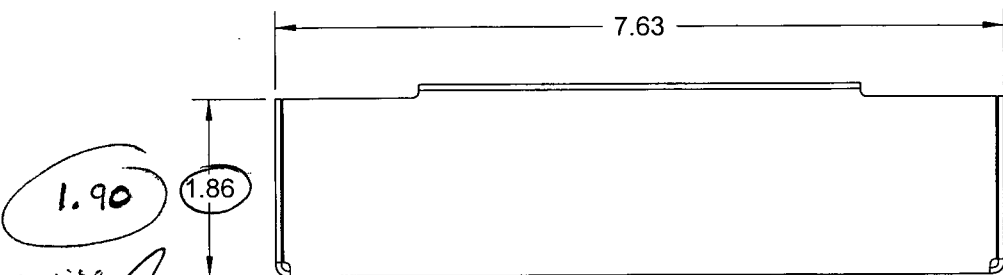
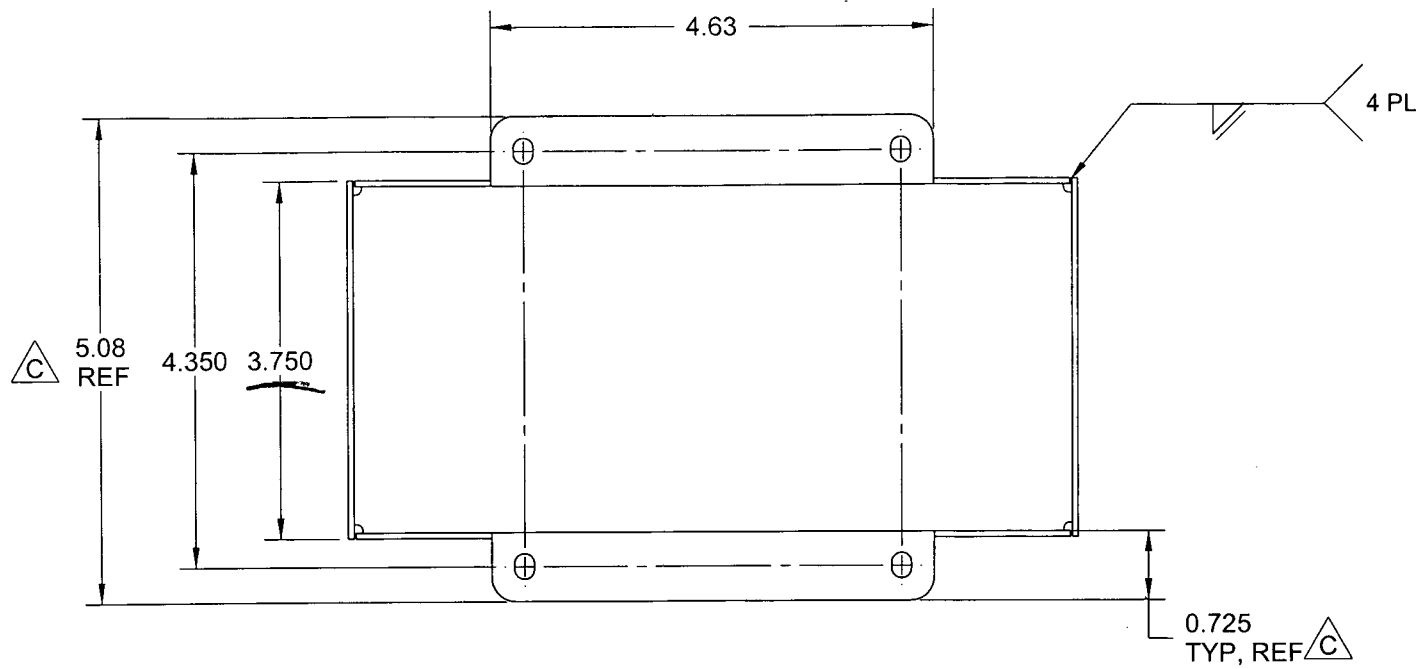
Product Name: EMERGENCY LITTER KIT

Requested By: AJS

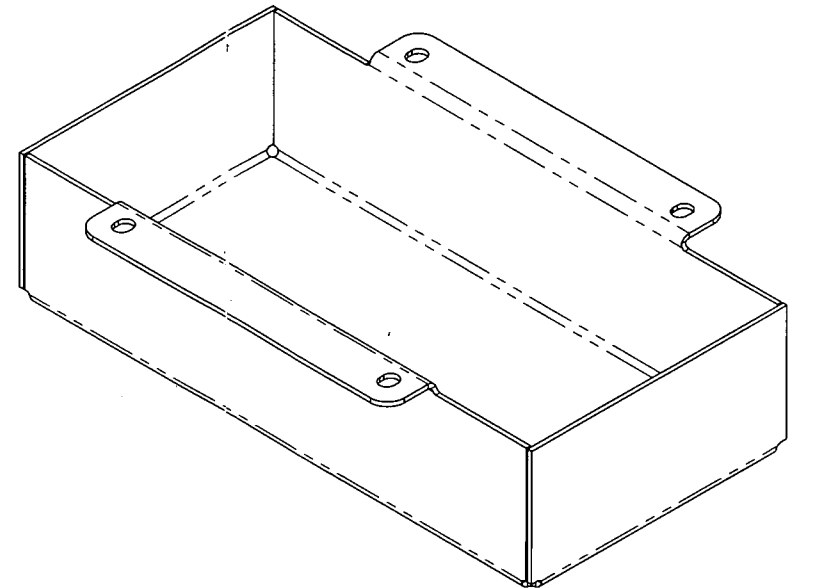
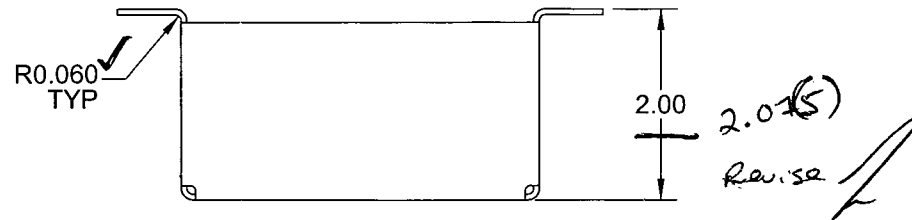
Design Manager Approval: 

[illegible]

FIRST ARTICLE INSPECTION CHECKLIST



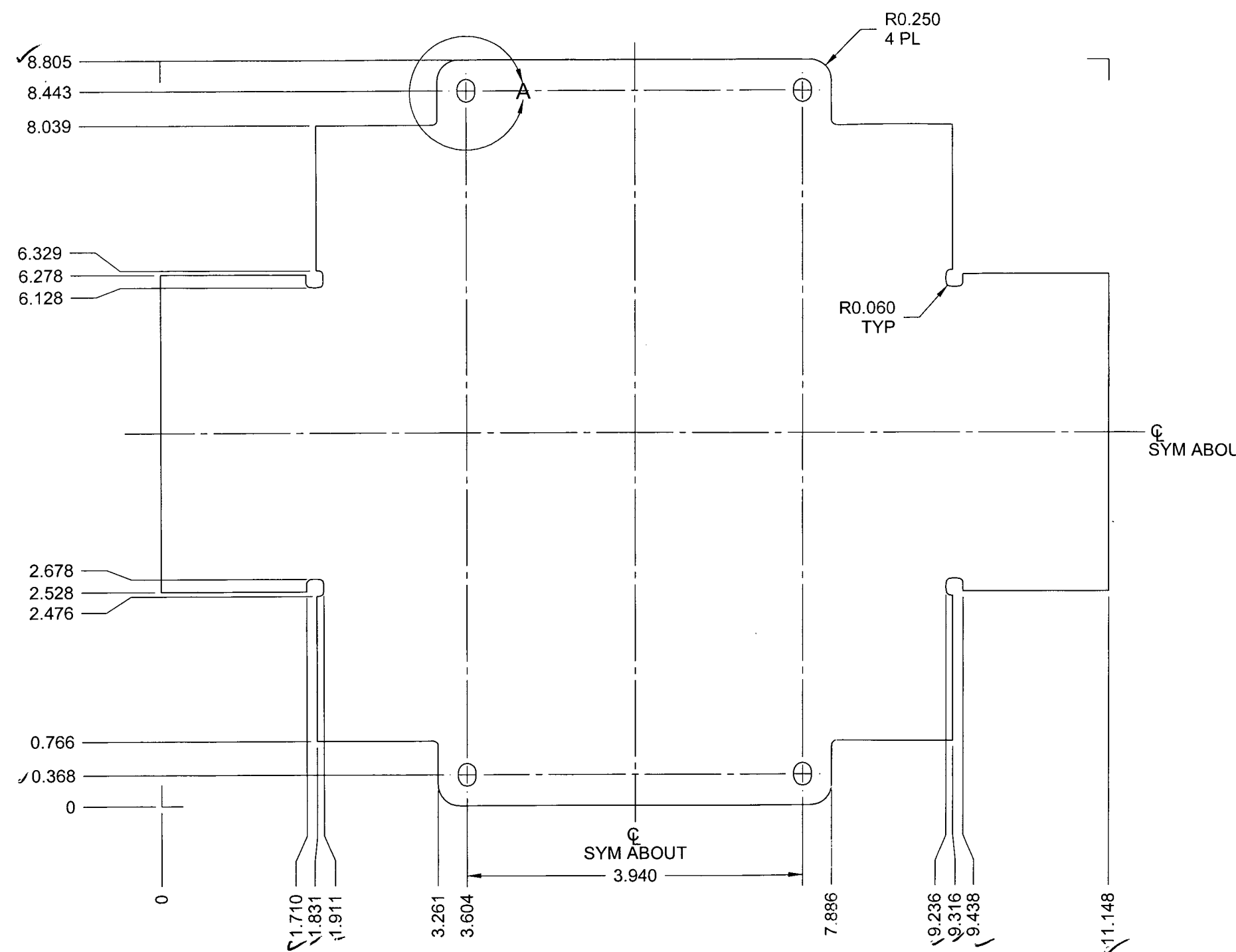
D3494-1 STUB COVER



PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
DSS 08.10.31

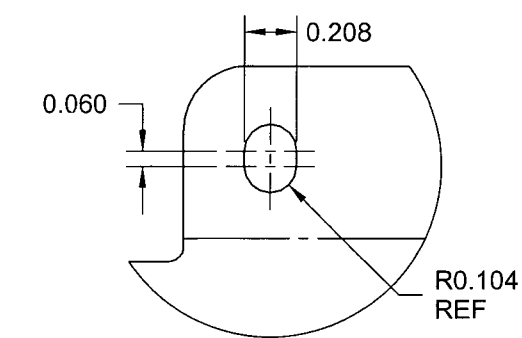
- NOTES:**
- 1) MATERIAL: MAKE FROM D3494-1F
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.44 lbs
 - 8) WELD PER DART QSI 004

| C | DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. C8-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". C5-1 0.725 DIM WAS 0.65. | AJS | 08.10.31 |
|------------|---|---|----------|
| B | REVISED FLAT PATTERN, BENDING DIMENSIONS, Ø0.208 X 0.268 SLOTS WERE Ø0.208 HOLES. | MB | 06.11.28 |
| A | NEW ISSUE | MB | 06.01.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3494 REV. C SHEET 1 OF 2 TITLE STUB COVER SCALE NTS <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.10.31 | | |



D3494-1F STUB COVER FLAT PATTERN

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
ASS 08.10.31



DETAIL A
SLOT DETAIL 4 PL
SCALE 2X

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL (0.060 THICK) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: SEE COMPLETED PART WEIGHT

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3494 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | STUB COVER | NTS |
| DATE | 08.10.31 | <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |